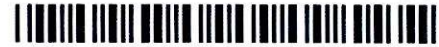




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3138-2
Job Sheet 202994



Part No: D3138-2

Job Qty: 3 pcs

Part Name: Cover Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/19

Job Tracking No:

Due Date: 11/21/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG D3138 REV.C IPP Rev: B 04.11.29 Made by Laser Cut KJ/RF IPP Rev: C 05.12.13

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	3 pcs		11/21/19	0.17	1.18	Waterjet - Flow		JRB 11/21/19
110	QC 2	3 pcs		11/21/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
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Email: sales@dartaero.com
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Container No: S235892



Part: D3138-2

Job No: 202994

Serial No/Batch: S235892

Revision: REV.C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/29/19

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120 QC 8	3 pcs	11/21/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 11/21/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS 11/22/2019 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - 2 - B4B	3 pcs	11/21/19	0.00 0.76	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	JUN 12 2020
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
140 QC 5	3 pcs	11/21/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	JUN 15 2020 DAS 40 9-89
				QC 5 - 61	

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150 Handfinish - 1-1 Chemical-B4B	3 pcs	11/21/19	0.00 0.44	QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
Handfinish - 1 - 22 - B4B					
160 Powdercoat - 3 Grey Sand - B4B	3 pcs	11/21/19	0.00 0.27	Powdercoat - 1 - B4B	20-06-18 34 9:89
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3	3 pcs	11/21/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				Plex 11/7/19 9:03 AM Dart.Renwick.Jennife	

Plex 11/7/19 9:03 AM Dart.Renwick.Jennifer

					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	DAS
					QC 3 - 24	82
					QC 3 - 61	9-89
					QC 3 - 81	0207 6 1 NHR
180	Packaging 3-1 - Stock - B4B	3	11/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	JUN 2 2 2020
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
190	QC 21 - SA	3	11/21/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs				QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89 JUN 2 2 2020

Part Op 100 - 1-Cut as per Dwg D3138 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Deburr Bend as per Dwg D3138

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - (Grey Sander)(Ref 4.3.5.6) per QSI005 4.3), START TIME: 7:30 OVEN TEMPERATURE: 320°

FINISH TIME: 8:00

170 - QC3- Inspect Part Finish

180 - (Identify as per dwg & Stock Location: _____), Location : CA2

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	5.5500 sf (1.85 ea)	100-Waterjet - Flow - 1	5209810

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	6	124	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cover	0.203Inches $\pm$ 0.010	0.213 0.193	0.209	
2	Cover	0.603Inches $\pm$ 0.010	0.613 0.593	0.608	
3	Cover	3.440Inches $\pm$ 0.030	3.470 3.410		
4	Cover	77.140Inches $\pm$ 0.030	77.170 77.110		
5	Cover	1.820Inches $\pm$ 0.030	1.850 1.790		
6	Cover	2.270Inches $\pm$ 0.030	2.300 2.240		
7	Cover	6.230Inches $\pm$ 0.030	6.260 6.200		
8	Cover	37.000Inches $\pm$ 0.030	37.030 36.970		
9	Cover	72.330Inches $\pm$ 0.030	72.360 72.300		
10	Cover	2.490Inches $\pm$ 0.030	2.520 2.460		

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